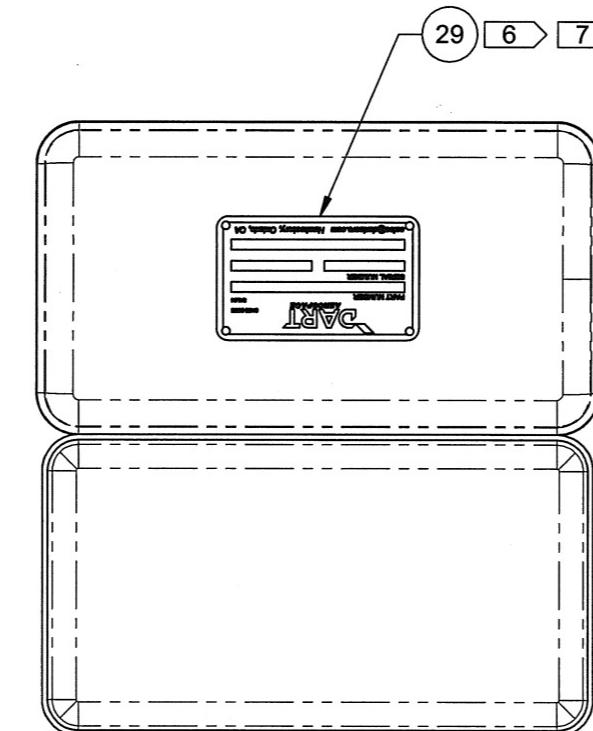
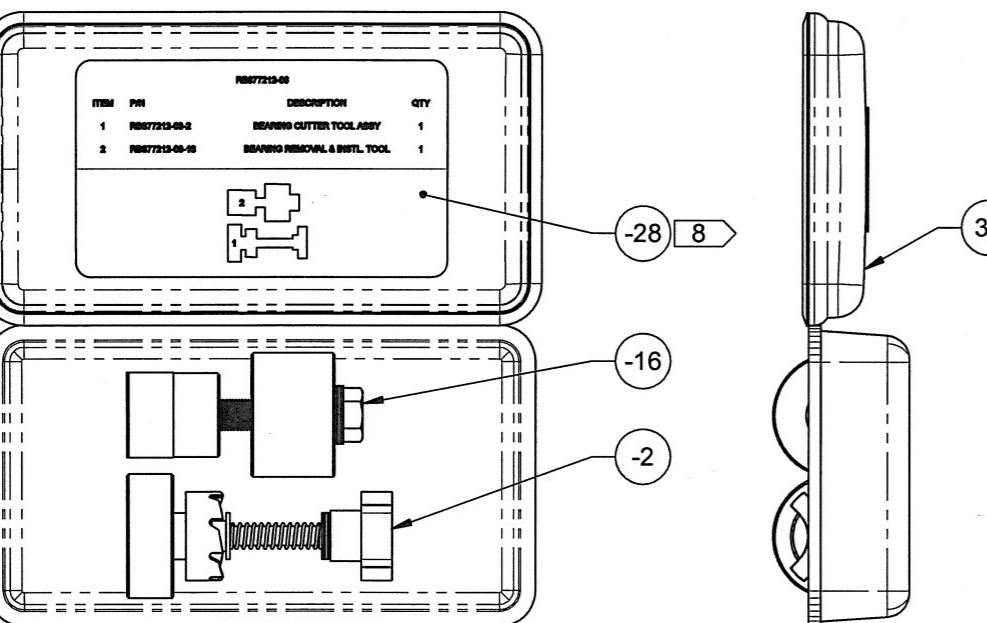


ITEM #	QTY	PART #	PART TITLE
-2	1	RB877212-08-2	BEARING CUTTER TOOL ASSY
-16	1	RB877212-08-16	BEARING REMOVAL & INSTALLATION TOOL ASSY
-28	1	RB877212-08-28	CONTENT PLACARD
29	1	RB41011	DART PLACARD
30	1	PELICAN #APP-1060-E	PELICAN CASE 1060

D



### RB877212-08 TAIL ROTOR BEARING CUTTER

#### NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
                   X.XX = +/- 0.01" / +/- 0.5°  
                   X.XXX = +/- 0.005" / +/- 0.1°  
                   X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

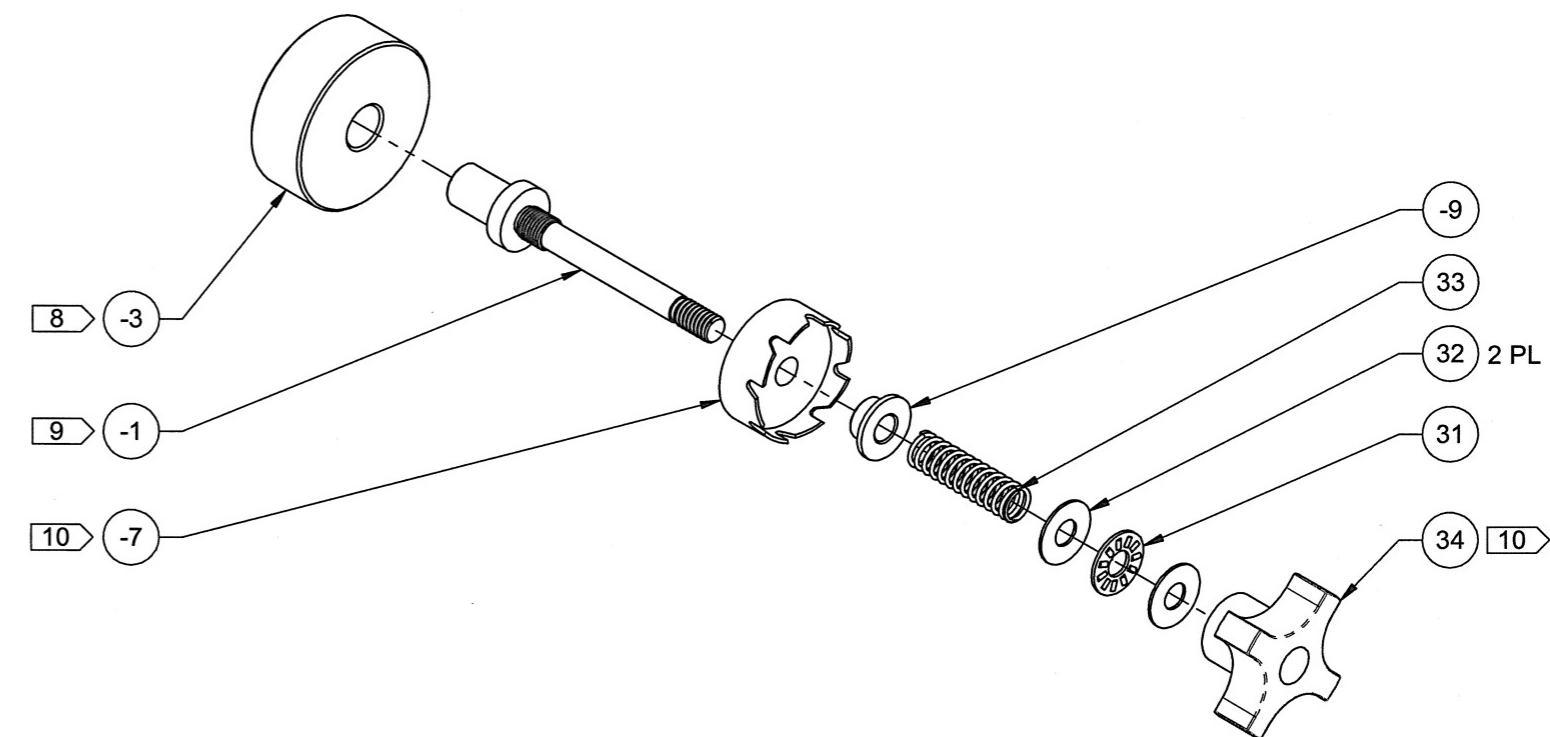
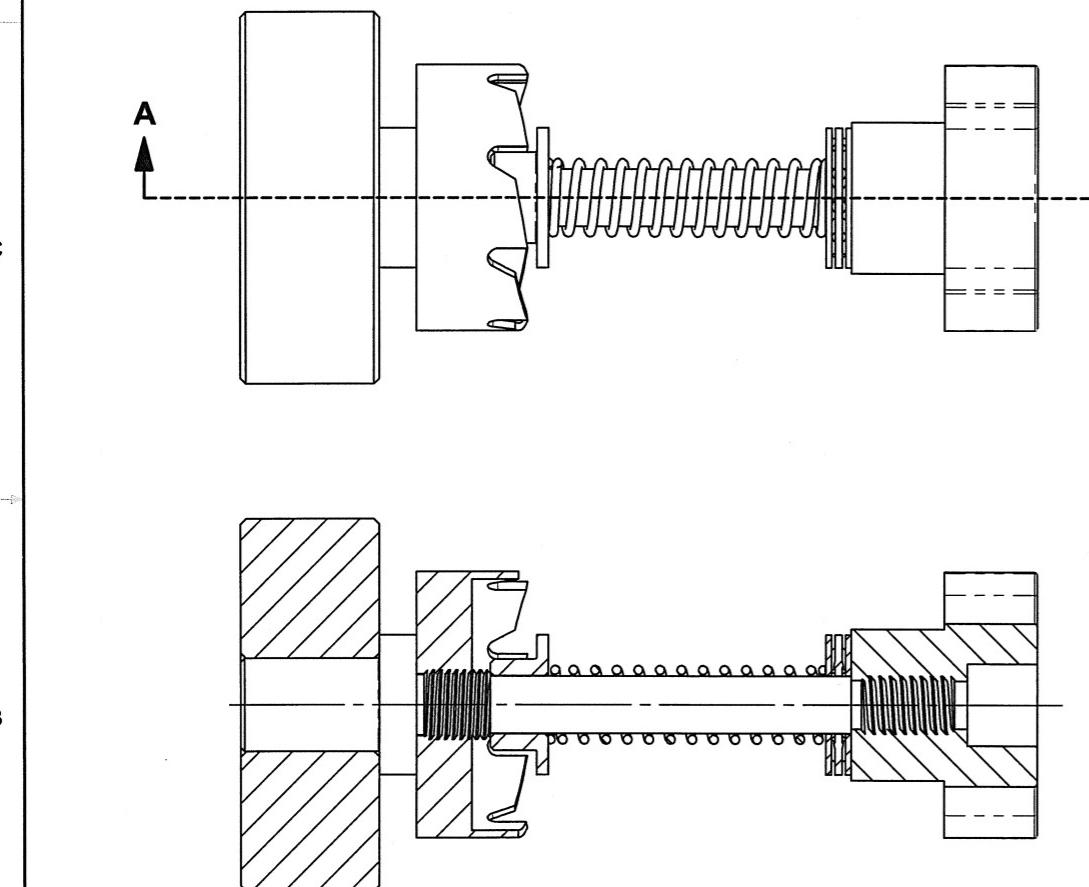
6) IDENTIFICATION: ENGRAVE THE TOOL P/N ON THE DART PLACARD WHERE INDICATED

7) HOT GLUE THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA

8) HOT GLUE THE CONTENT PLACARD ONTO THE CASE

SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE ADDED ITEMS -28, 29 & 30		
<p>-1 DIM WAS Ø0.498 TAPPER IS Ø0.5000 +0.0008/-0.0000. DIM WAS 0.750 IS 0.75. DIM WAS 3.850 IS 3.85. DIM WAS 0.400 IS 0.40. DIM WAS 0.500 IS 0.56. DIM 0.250 &amp; 2.000 DELETED. ADDED DIM R0.008 MAX, 0.02 X 45.0° CMF &amp; 2.90</p> <p>-3 DIM WAS Ø0.500 IS Ø0.5000 +0.0000/-0.0008. ADDED DIM 0.03 X 45.0° CMF 4 PL. FINISH WAS BLACK ANODIZE IS RED ANODIZE. T/N ENGRAVING WAS RB877212-8 IS RB877212-08-2</p> <p>-7 DIM WAS 1.430±0.002 IS 1.430±0.001. DIM WAS 0.38 IS 0.372. DIM WAS 0.18 IS 0.175. ADDED DIM 0.216 &amp; R0.06. DELETED DIM 5°. DELETED NOTE MACHINE TO 1.445 +0.005/-0.003 GRIND TO SIZE AFTER HEAT TREAT. ADDED FINISH BLACK OXIDE</p> <p>-9 DIM WAS Ø0.312 IS Ø0.313 +0.010/-0.000. ADDED DIM R0.008 MAX &amp; 0.02 X 45.0° CMF 3 PL. MATERIAL WAS STRESSTPROOF IS 4140 (28-32). FINISH WAS BLACK OXIDE IS ZINC PLATE</p> <p>-17 DIM WAS Ø1.350 ±0.002 IS Ø1.350 ±0.001. ADDED DIM R0.008 MAX 2 PL &amp; 0.03 X 45.0° CMF 3 PL</p> <p>-21 DIM WAS Ø0.500 IS Ø0.510 +0.010/-0.000. ADDED DIM R0.02 &amp; 0.03 X 45.0° CMF 3 PL. DIM WAS 1.350 IS 1.35. DIM WAS 0.850 IS 0.85. FINISH WAS BLACK ANODIZE IS RED ANOZIE</p> <p>-27 WAS MODIFIED PART IS MACHINED PART</p>		
REV.	DESCRIPTION	ECN #
DRAWN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RB877212-08
APPROVED	WY	REV. D SHEET 1 OF 11
DATE 3/21/2019		SCALE NTS
TAIL ROTOR BEARING CUTTER		
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ITEM #	QTY	PART #	PART TITLE
-1	1	RB877212-08-1	SHAFT
-3	1	RB877212-08-3	HANDLE
-7	1	RB877212-08-7	CUTTER
-9	1	RB877212-08-9	SPRING GUIDE
31	1	NTA-512	NEEDLE ROLLER THRUST BEARING 5/16" ID. X 3/4" OD. X 5/64" WD.
32	2	TRA-512	THRUST WASHER 5/16" ID. X 3/4" OD. X 0.03" WD.
33	1	McMaster#9657K389 OR EQUIV.	ZINC PLATED MUSIC WIRE COMPRESSION SPRING 2" LG. x 0.42" OD. x 0.326" ID. CLOSE AND GROUND ENDS
34	1	Reid#DK-55 OR EQUIV.	KNOB 4-PRONG 5/16-18 UNC



**RB877212-08-2 BEARING CUTTER TOOL ASSY**

11

**SECTION A-A**

**NOTES:**

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -3 WITH ITEM -1, AND REMOVE EXCESS

9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS 3/8"-24 UNF ONLY OF ITEM -1 THEN ASSEMBLE WITH ITEM -7, AND REMOVE EXCESS

10) INSTALL ITEMS -7 & 34 HAND TIGHT

11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	WJ		
TOOL PART #		REV. D	
RB877212-08		SHEET 2 OF 11	
TITLE		SCALE	
TAIL ROTOR BEARING CUTTER		NTS	
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DATE 3/21/2019

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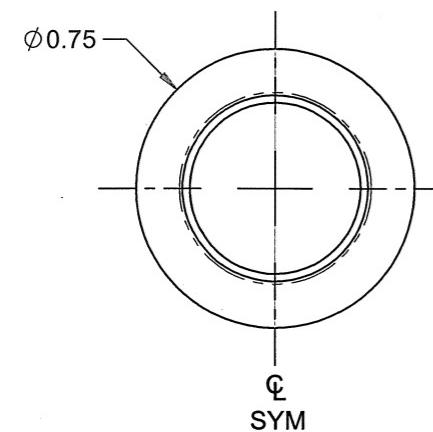
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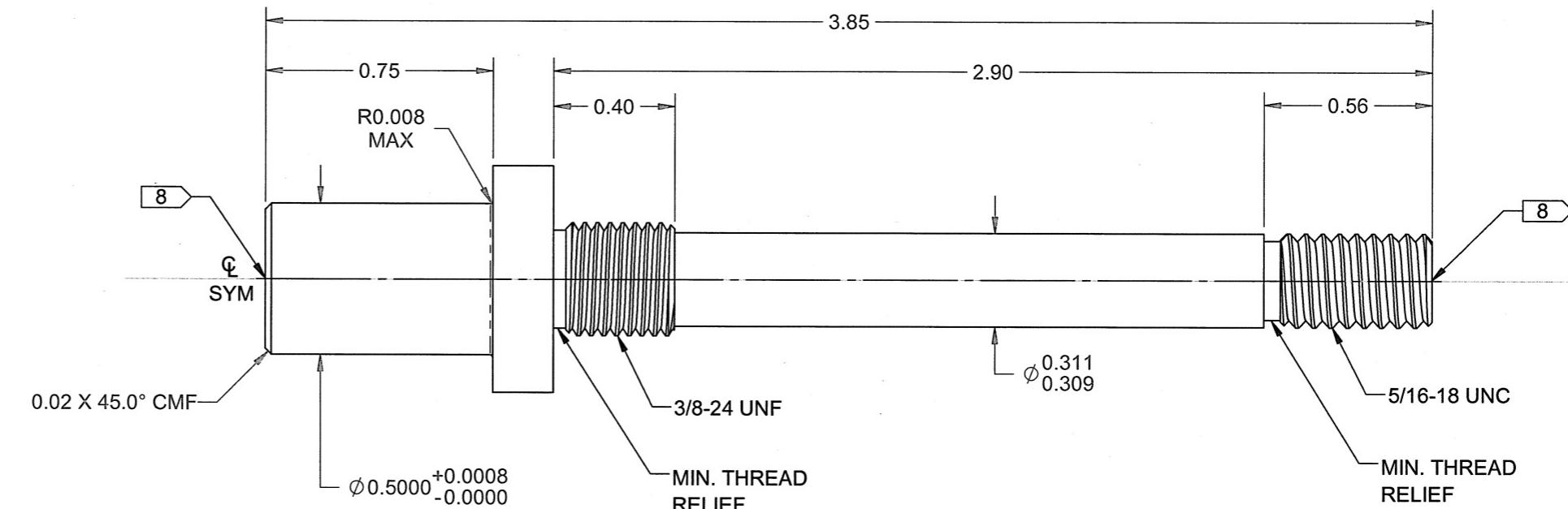
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**RB877212-08-1 SHAFT**



**NOTES:**

- 1) MATERIAL: 1144 STRESSPROOF
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	MBB MBB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	<b>RB877212-08</b>
APPROVED	VJ	TITLE
DATE	3/21/2019	SCALE NTS
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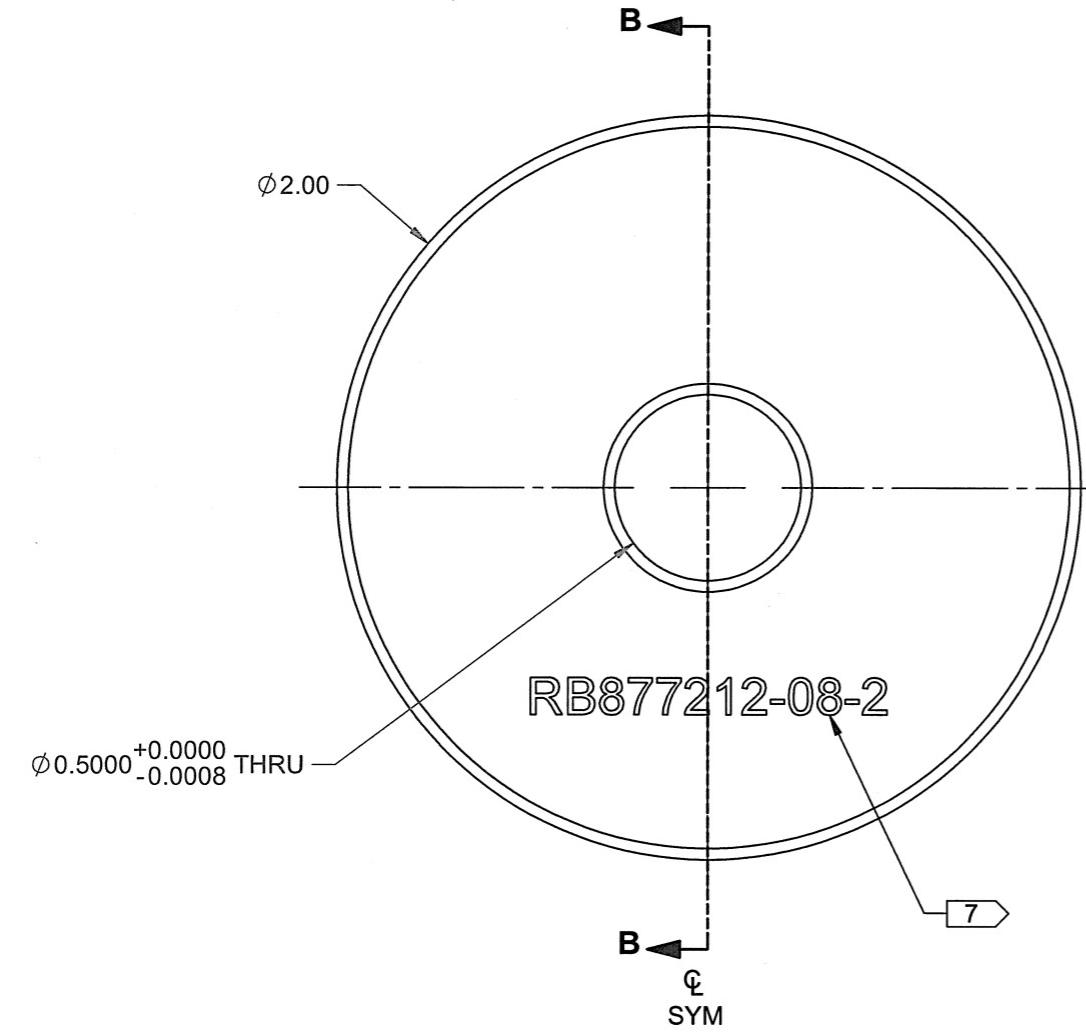
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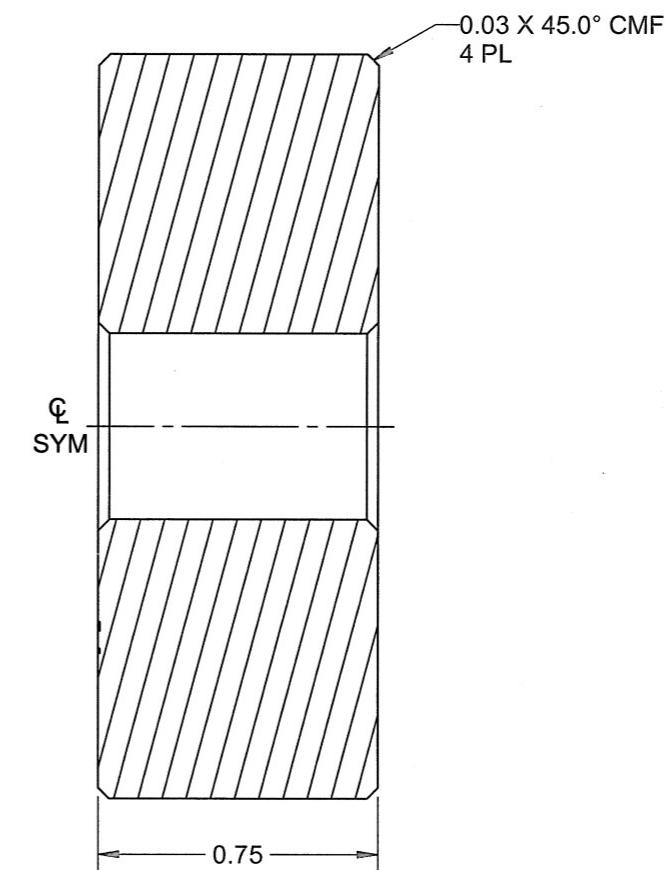
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**RB877212-08-3 HANDLE**



**SECTION B-B**

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	MBB	DART AEROSPACE LTD
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RB877212-08
APPROVED	VJ	REV. D
		SHEET 4 OF 11
DATE	3/21/2019	SCALE
		NTS
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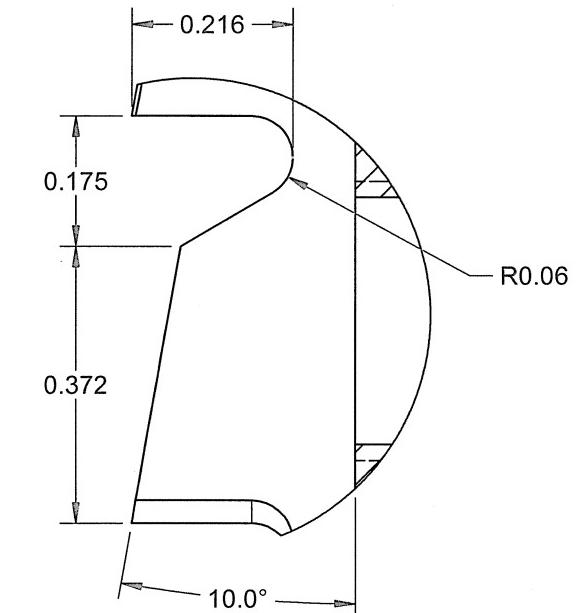
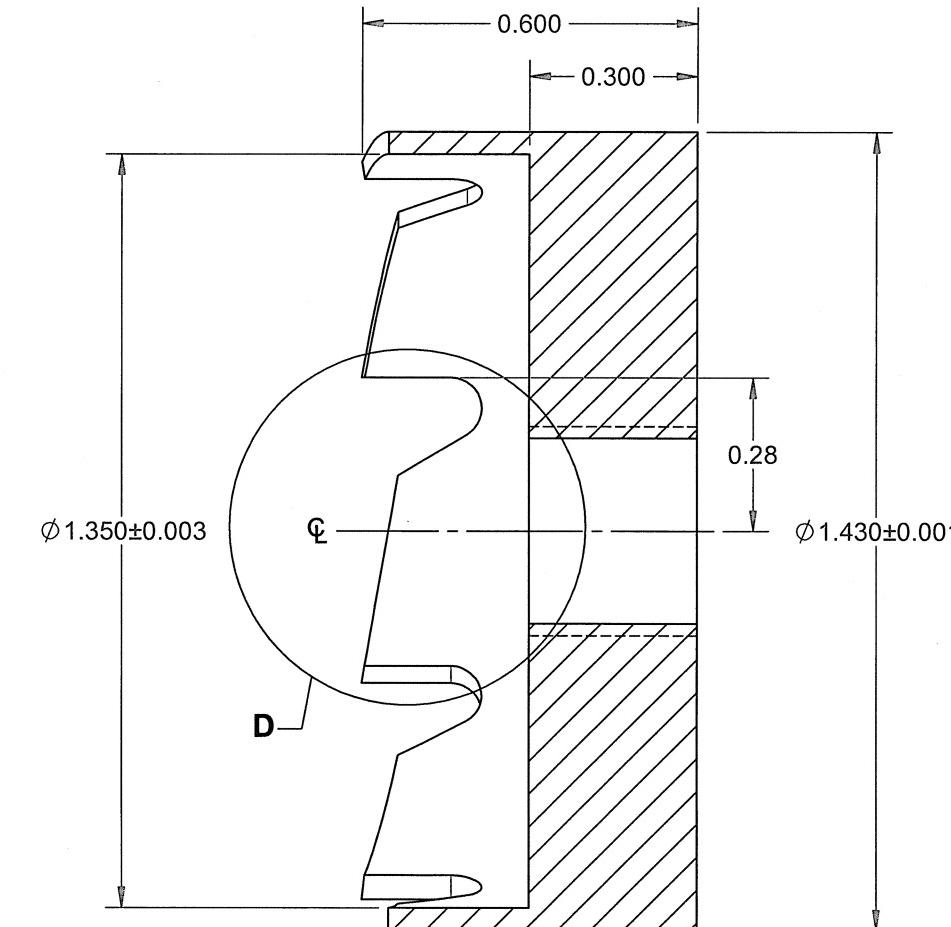
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### RB877212-08-7 CUTTER

#### NOTES:

- 1) MATERIAL: O1
- 2) HEAT TREAT: 50-60 RC
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	MBB MBB	DART AEROSPACE LTD
CHECKED	MBB	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	DP	TOOL PART #
APPROVED	W	RB877212-08
DATE 3/21/2019		REV. D
		SHEET 5 OF 11
		SCALE NTS
TITLE TAIL ROTOR BEARING CUTTER		
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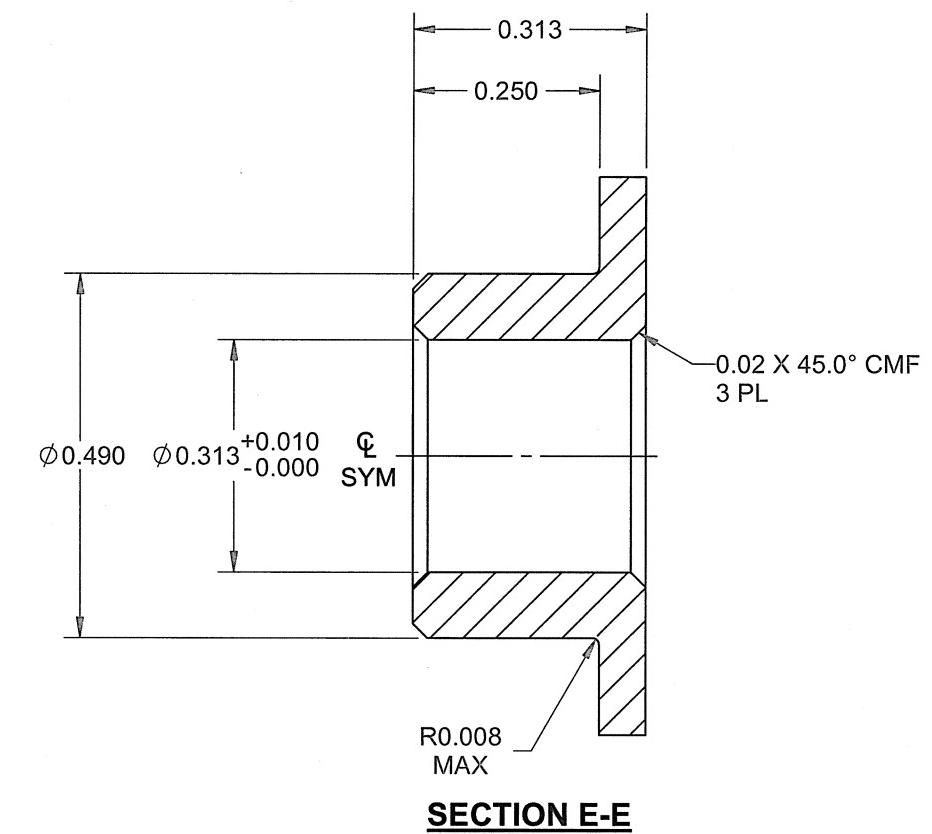
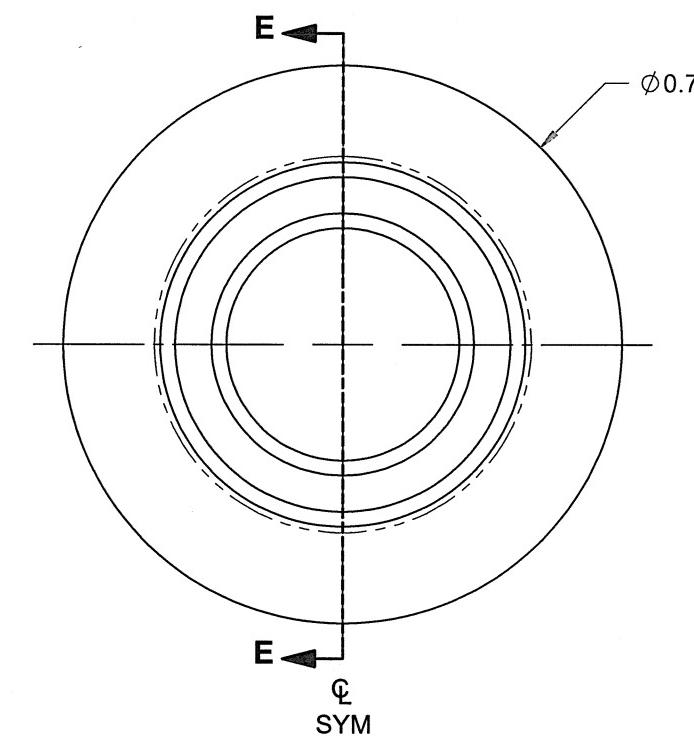
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**RB877212-08-9 SPRING GUIDE**

**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X =  $+/- 0.1"$  /  $+/- 1^{\circ}$   
 $X.XX = +/- 0.01"$  /  $+/- 0.5^{\circ}$   
 $X.XXX = +/- 0.005"$  /  $+/- 0.1^{\circ}$   
 $X.XXXX = +/- 0.0005"$  /  $+/- 0.05^{\circ}$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	MBB	<b>DART AEROSPACE LTD</b>	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB		
MFG. APPR.	DP	TOOL PART #	
APPROVED	WJ	RB877212-08	
DATE 3/21/2019		TITLE	TAIL ROTOR BEARING CUTTER
REV. D		SCALE	NTS
SHEET 6 OF 11		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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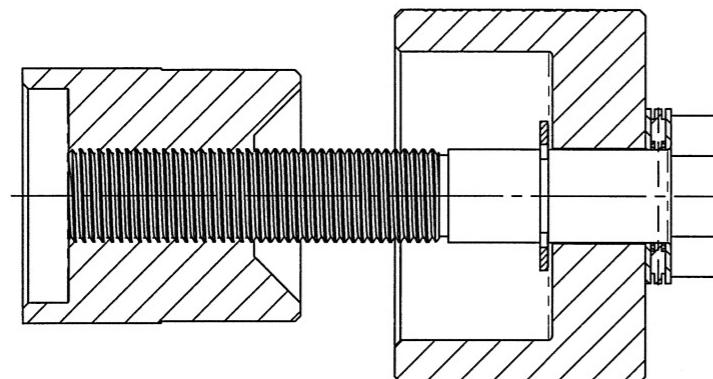
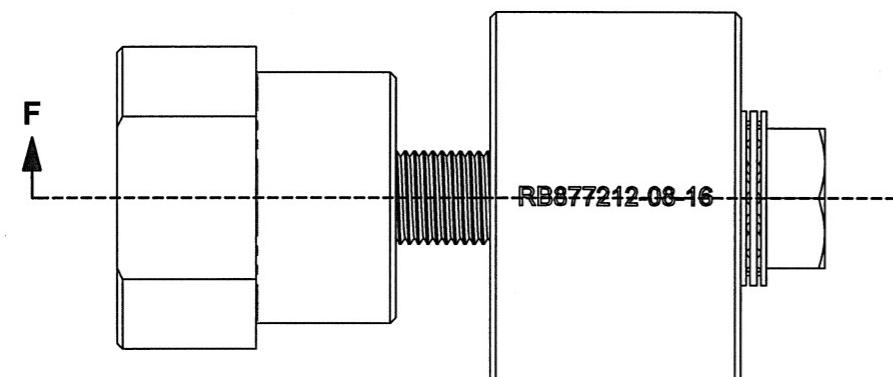
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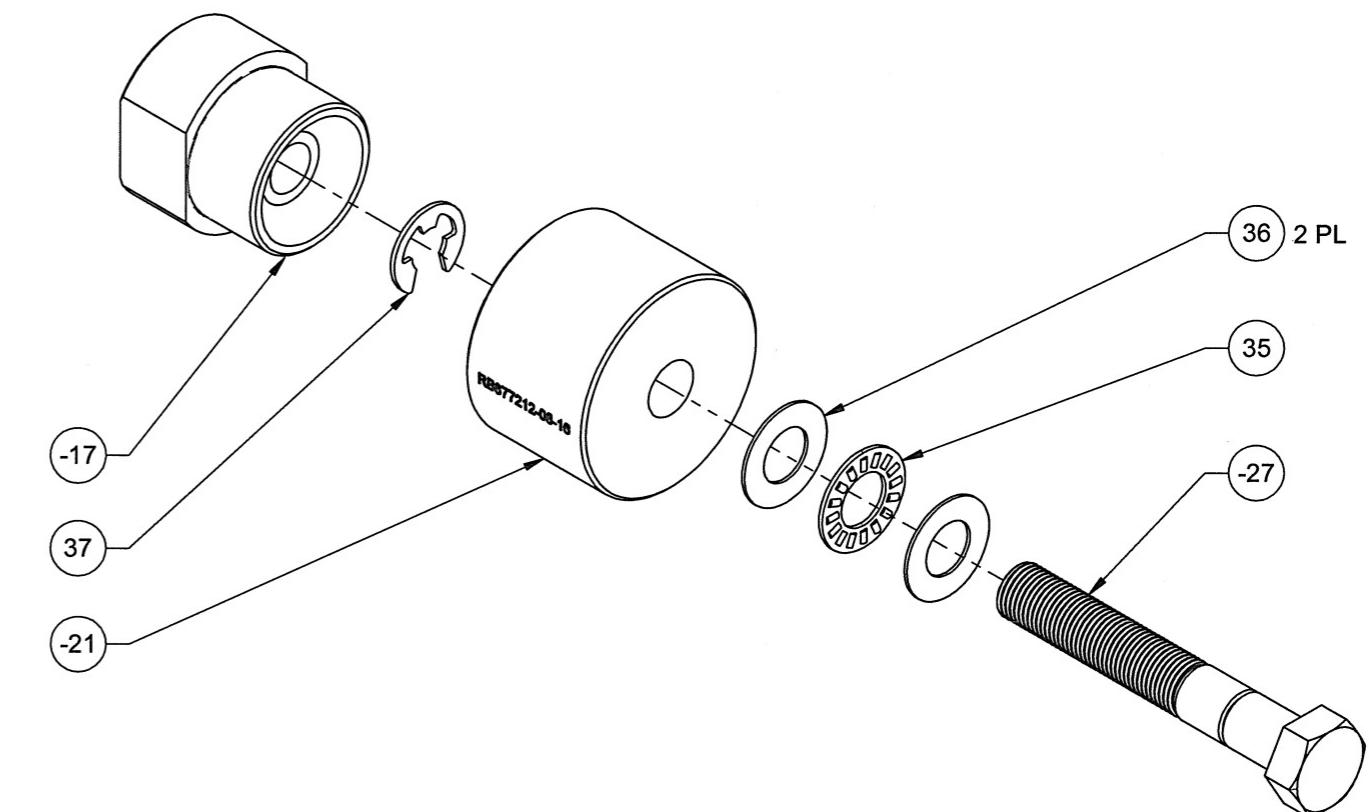
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ITEM #	QTY	PART #	PART TITLE
-17	1	RB877212-08-17	R & I ADAPTER
-21	1	RB877212-08-21	CAP
-27	1	RB877212-08-27	BOLT
35	1	NTA-815	NEEDLE ROLLER THRUST BEARING 1/2" ID. X 15/16" OD. X 5/64" WD.
36	2	TRA-815	THRUST WASHER 5/16" ID. X 3/4" OD. X 0.03" WD.
37	1	McMaster#98407A138 OR EQUIV.	ZINC PLATED SPRING STEEL SIDE-MOUNT EXTERNAL RETAINING RING FOR GROOVE 0.396" OD. X 0.046" WD.



SECTION F-F



RB877212-08-16 BEARING REMOVAL &amp; INSTALLATION TOOL ASSY

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## NOTES:

1) MATERIAL: N/A  
2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

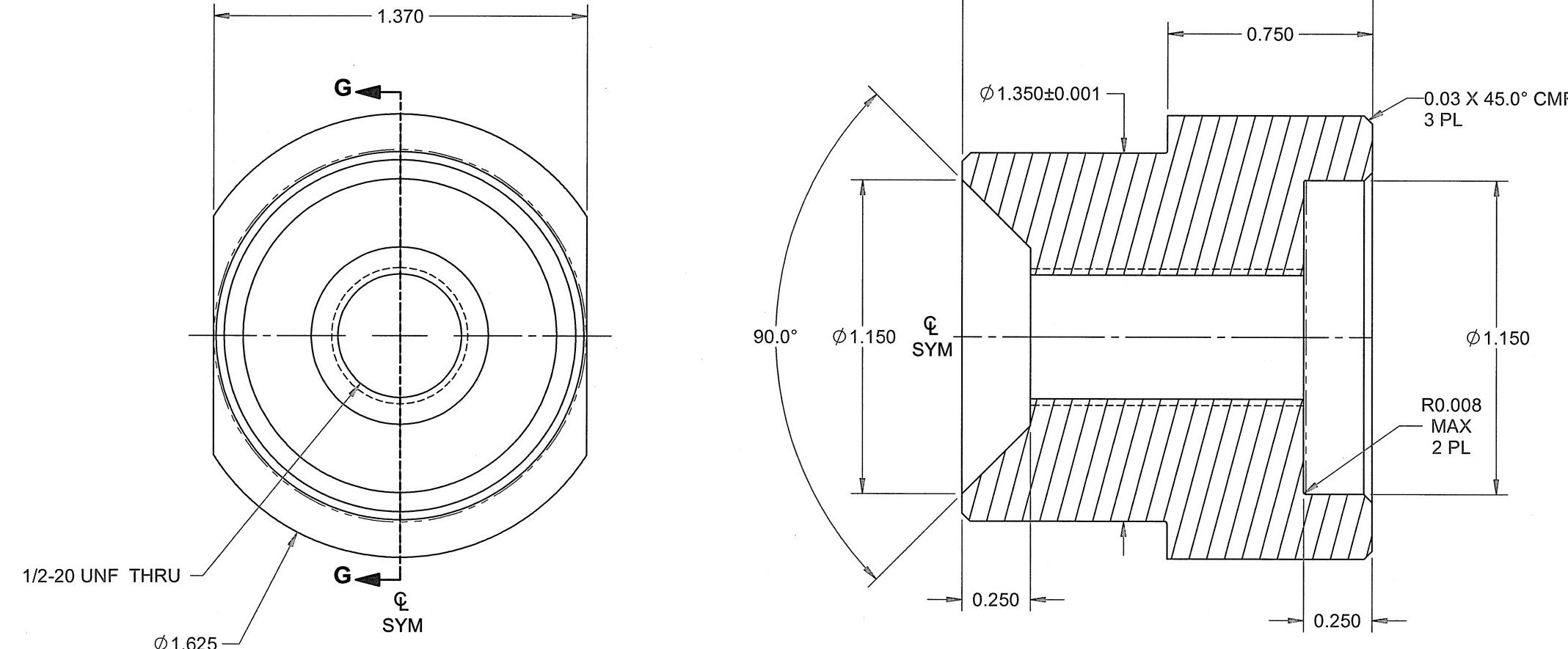
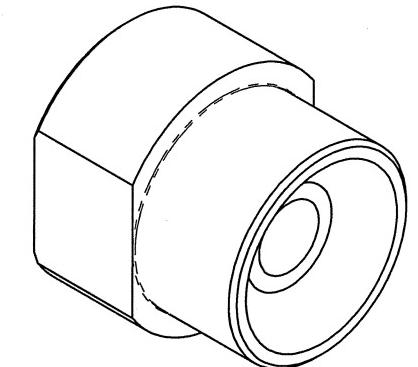
8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN DRAWN	MBB MBB	DART AEROSPACE LTD	
CHECKED	MBB	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	TOOL PART #	REV. D
APPROVED	W	RB877212-08	SHEET 7 OF 11
DATE 3/21/2019		TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
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RB877212-08-17 R & I ADAPTER

## NOTES

- NOTES:  
1) MATERIAL: 1144 STRESSPROOF  
2) HEAT TREAT: N/A  
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PREF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III

OIL / CPC PER MIL-PRF-1617  
QB MIL-C-23411A QB MIL-PR

4) TOLERANCES: X X

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005"

X.XXXX = +/- 0.0005" / +/- 0

#### PARALLELISM ECCENTRICITY

PARALLELISM, ECCENTRIC  
5) UNITS: INCHES UNLESS OTHERWISE NOTE

5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) REMOVE ALL SHARP EDGES AND BURRS

#### **6) REMOVE ALL SHARP EDGES**

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 8 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE NTS
DATE	3/21/2019	TAIL ROTOR BEARING CUTTER	

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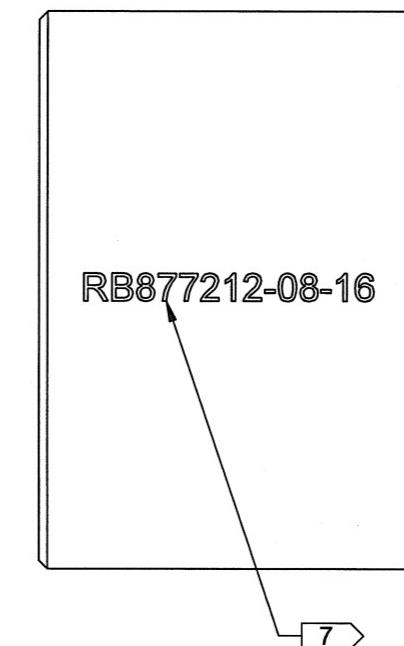
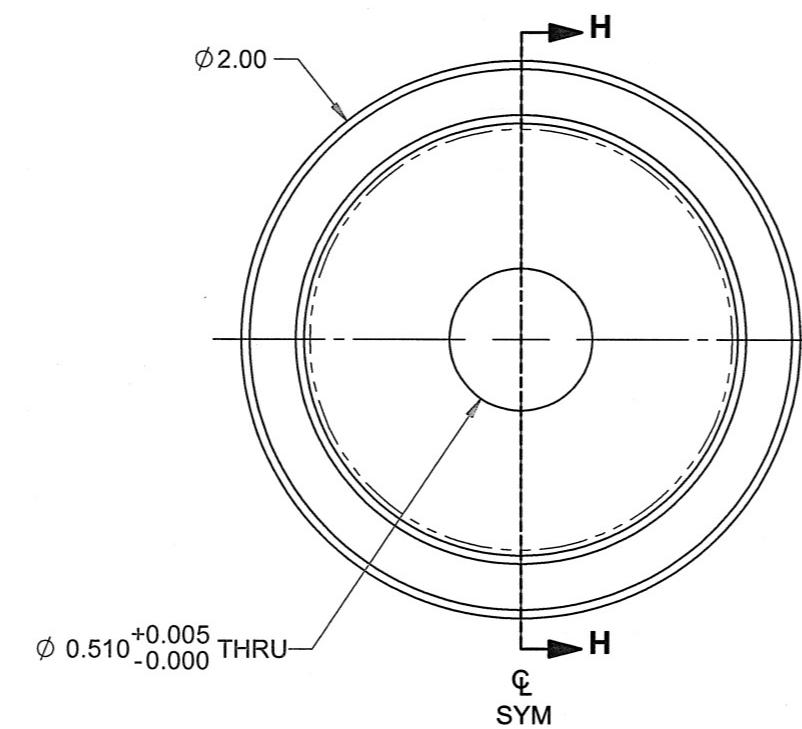
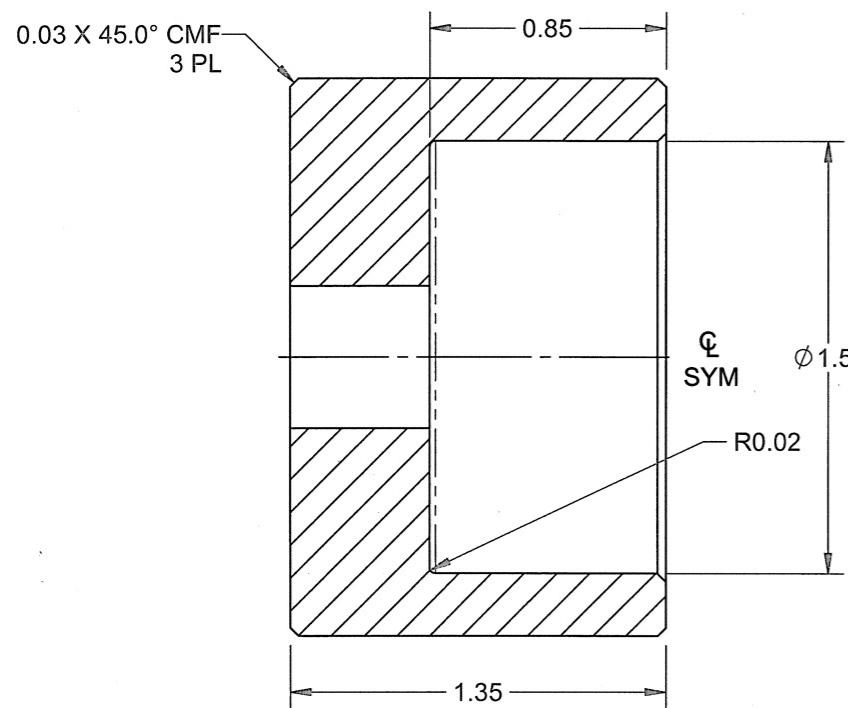
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**SECTION H-H****RB877212-08-21 CAP****NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	MBB	DART AEROSPACE LTD
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RB877212-08
APPROVED	VIP	REV. D
		SHEET 9 OF 11
DATE	3/21/2019	SCALE
		NTS
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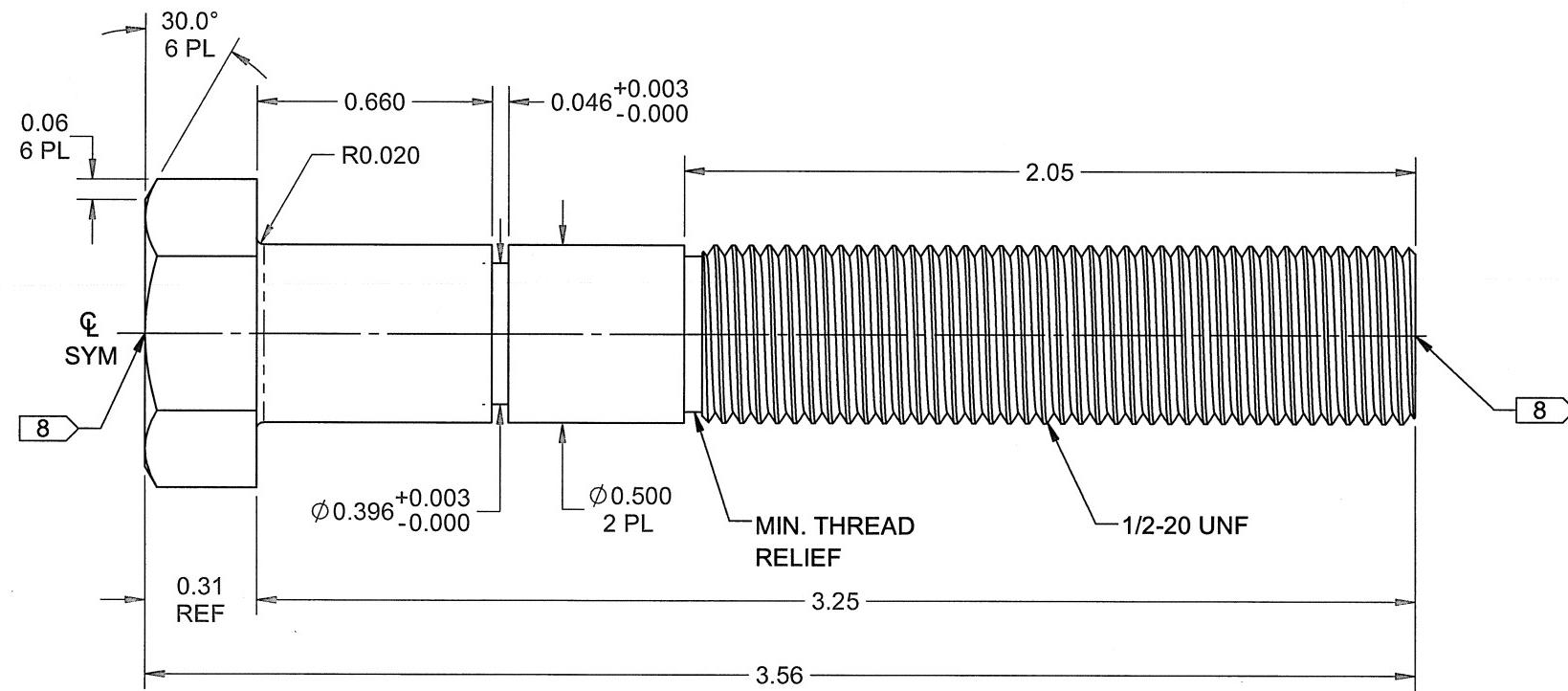
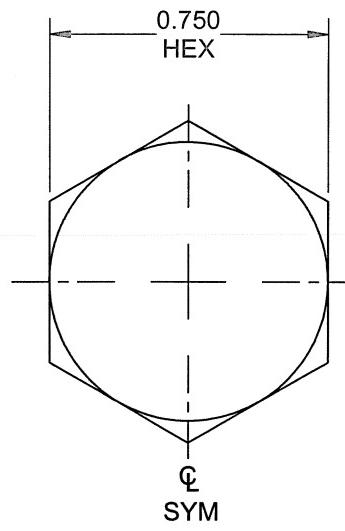
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**RB877212-08-27 BOLT**



**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	MBB MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RB877212-08
APPROVED	VJ	REV. D SHEET 10 OF 11
DATE	3/21/2019	SCALE NTS
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ITEM	P/N	DESCRIPTION	QTY
1	RB877212-08-2	BEARING CUTTER TOOL ASSY	1
2	RB877212-08-16	BEARING REMOVAL & INSTL. TOOL	1

3.50

6.00

RB877212-08-28 CONTENT PLACARD

8

## NOTES

- NOTES:  
1) MATERIAL: JOHNSON PLASTICS #LM922402 OR EQUIV. (BLACK/WHITE MICROSURFACED IMPACT ACRYLIC 1/16" THK.  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) BLACK BACKGROUND WITH WHITE LETTERS AND LINES  
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB877212-08-28 REV.

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 11 OF 11
APPROVED	<i>Vf</i>	TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
DATE	3/21/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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